

## Standards

TS EN ISO 14174	: SA AB 1 68 AC H5
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AWS A5.17	: F7A4-EH12K/ F7A4-EM12 F7A4-EM12K
AWS A5.23	: F8A4-EA2-A3 / F11A4-EM4(mod)-M4

Basicity
2.1

## Mechanical Properties

SAW Wire	AWS A5.17 AWS A5.23	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (Lo=5do) (%)	Impact Strength ISO-V(J)		
					-20°C	-30°C	-40°C
S2	F7A4-EM12	430	525	29	---	---	60
S2Si	F7A4-EM12K	440	550	28	100	---	65
S2 Mo	F8A4-EA2-A3	500	600	26	---	---	60
S3Si	F7A4-EH12K	545	645	26	---	---	60
S3NiCrMo2.5	F11A4-EM4(mod)-M4	735	855	18	---	70	60

## Chemical Composition of Weld Metal - % (Typical)

Saw Wire	C	Si	Mn	Mo	Ni	Cr
S2	0.08	0.40	1.50	---	---	---
S2 Si	0.07	0.45	1.60	---	---	---
S2 Mo	0.07	0.55	1.70	0.50	---	---
S3 Si	0.07	0.60	1.70	---	---	---
S3 NiCrMo 2.5	0.05	0.65	1.80	0.48	2.05	0.35

## Features and Applications

- SAW Flux type is composed of agglomerated Aluminate Basic.
- Weld beads of excellent surface appearance.
- Slag can be removed easily.
- This product has high current carrying capacity.
- GeKa ELIFLUX BAB-S is suitable for multipass and tandem welding especially for manufacturing of spiral pipe.
- It has suitable of high working speed.
- Suitable for the use of welding of high strength steels.
- Process requirement of re-drying at 300°C - 350°C for 2 hours.

## Operating Data

Product Code	Package Weight (Kg)	Package Type
3010800022	25	Kraft Bag

**Approvals:** ELIFLUX BAB-S: CE, GOST-R, SEPRO • S2 x ELIFLUX BAB-S: ABS • S3Si x ELIFLUX BAB-S: ABS  
S2Mo x ELIFLUX BAB-S: ABS • S3NiCrMo2.5 x ELIFLUX BAB-S: ABS,